

Work Order ID 63724

November 16, 2010 9:23:38 AM

Page 1

Item ID: D4012-1

Accept

Revision ID:

Item Name: Cushion

Start Date: 11/11/10 Start Qty: 14.00

Required Date: 11/12/10 Req'd Qty: 14.00

Reference:

Approvals: Process Plan: 

QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4012

A

105

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

mill to size per drwg D4012 rev.A

~~10~~ 10/11/18

17

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

~~10~~ 10/11/19

17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Schulig

17

was told by MB that
Flat pattern will work.
Dy doesn't show a Flat Pattern.

W/O: 63724		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.11.15	100	ACCEPTABLE TO USE DSC-D4287-3. SEE ATTACHED DWG, DRAWING REQUEST UPDATE AS PER HAND CHANGES.	* FE	10.11.25		10.11.15	
		D 4011-1 B S 3978 * will wait for dwg to be released on ECN	FE				

Part No: D4012-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.11.15	100							

NOTE: Date & initial all entries

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Item ID: D4012-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cushion

Start Date: 11/11/10 Start Qty: 14.00



Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

125

0.00



Small Fab

Memo

0.00

Small Fab

form per drwg

So 10/11/23

17

126

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

So 10/11/23

17

130

Identify as per dwg & Stock Location: 459

0.00



Packaging

Memo

0.00

Packaging

10/11/25 17

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Item ID: D4012-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cushion

Start Date: 11/11/10 Start Qty: 14.00



Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 14.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/25

MF

10-11-25

Picklist Print

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Page 1

Work Order ID: 63724

Parent Item: D4012-1

Parent Item Name: Cushion



Start Date: 11/11/10

Required Date: 11/12/10

Start Qty: 14.00

Required Qty: 14.00

Comments:

IPP RevA: New issue 09.10.28 DD verified by:JLM
revA as per dwg 09.11.18 DD verified by:JLM

IPP RevB:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4287-3

Manufactured

No

f

0.0000

0.4



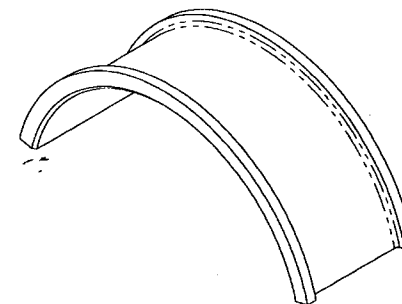
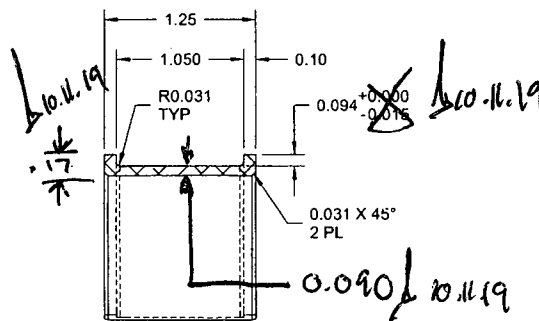
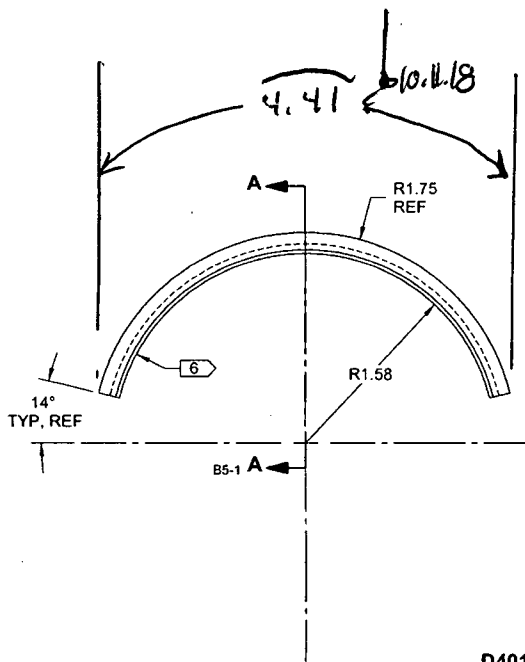
UHMW U-Channel



AO

63829

10/11/25



SECTION A-A B7-1

D4012-1 CUSHION

W/O 63724

RELEASED
2009-11-24

NOTES:

- 1) MATERIAL: UHMW TUBING, 3.500 OD X 0.250 MIN WALL
REF. DART SPEC. MUHMWTR3.500W.XXXB OR MUHMWTR3.500B.XXXW
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

OR D4287-3 10.11.18

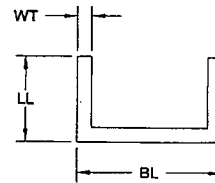
REV.	NEW ISSUE	DESCRIPTION	MB	09.10.19
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DATE				

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D4012 SHEET 1 OF 1
TITLE SCALE
CUSHION

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SPECIFICATION CONTROL DRAWING



63724

D4287-X UHMW U-CHANNEL

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	PURCHASED LENGTH	BASE LENGTH (BL)	LEG LENGTH (LL)	WALL THICKNESS (WT)	WEIGHT (lbs)
D4287-1	McMASTER-CARR	9928K53	UHMW (WHITE)	96.0	1.05	0.75	0.250	2.11
D4287-3	McMASTER-CARR	8672K31	UHMW (WHITE)	96.0	1.25	0.75	0.125	1.29

RELEASED
2010-11-03

NOTES:

- 1) MATERIAL: PURCHASE PER TABLE
OR
UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMW
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PFR TABLE

A		NEW ISSUE		MB	10.10.26
REV.		DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. DSC-D4287 REV. A SHEET 1 OF 1 TITLE UHMW U-CHANNEL SCALE NTS			
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
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